

Work Order ID 153621

Tuesday, November 22, 2016 3:08:31 PM

153621

Page 1

Item ID: PB67-43001-45

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Longitudinal Support

Start Date: 11/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: UMF Date: 16-11-22

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-45	<u>1</u>
--------------	----------

100

Small Fab

0.00

100

Small Fab

Memo

0.05

Small Fab

1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg

2- Install spring pin

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

M, 13-10-12
Green Sandtex (Ref: 4.3.5.8) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.01

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40320°4:101 DC 2016/12/20① 16-12-20 ①1 φ 16-12-21 338

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

1 DEC 22 2016 CPC

140

Small Fab

0.00

140

Small Fab

Memo

0.07

Small Fab

Assemble parts as per dwg

1 CPC DA 2016/12/22

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

1 17-01-05 DAS
9
9-89

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Page 3

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Required Date: 12/2/2016 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ME222</i>	0.00				<i>1</i>		JAN 05 2017	<i>lpl</i>
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02					<i>DAS 21 9-89</i>	JAN 05 2017	
Quality Control									

*DAS
21
9-89*

JAN 05 2017

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Page 1

Work Order ID: 153621

153621

Parent Item: PB67-43001-45

PR67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 11/23/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
16.11.22 DWG REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149DN632J

Purchased

No

140

Each

429.0000

1

1

NAS1149DN632.J

Washer

Location

Loc Qty

Loc Code

ST265

429

m134370

429

MF 16-11-24

PB67-43001-97

Manufactured

No

100

Each

5.0000

1

1

PR67-43001-97

Clevis

Location

Loc Qty

Loc Code

Mezz2

5

148808

5

MF 16-11-24

PB67-43001-357

Manufactured

No

100

Each

1.0000

1

1

PR67-43001-357

Tube Arm

Location

Loc Qty

Loc Code

WA004

1

142413

1

MF 16-11-24

240-107

Purchased

No

100

Each

153.0000

1

1

240-107

SPRING SLOTTED PIN

Location

Loc Qty

Loc Code

ST579

153

m132006

12

m134651

141

MF 16-11-24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Parent Item: PB67-43001-45

PR67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 11/23/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

D3447-1 Manufactured No

140

Each

0.0000

1

1

D3447-1

Round Spacer

153588 LMF 16-11-30

D3447-5 Manufactured No

140

Each

0.0000

1

1

D3447-5

Clevis

1 DG 2016/12/20

30345T21 Purchased No

140

Each

32.0000

1

1

30345T21

LANYARD

Location

Loc Qty

Loc Code

ST570

2

M132610

2

ST581

30

M135014

12

M135998

18

LMF 16-11-24

AN4-13A Purchased No

140

Each

728.0000

1

1

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

76

m134634

19

m135470

57

over003

400

m136147

400

ST343

232

m134852

36

m135966

196

LMF 16-11-24

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WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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153621

Parent Item: PB67-43001-45

PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 11/23/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

BSP43

Purchased

No

140

Each

22.0000

1

1

BSP43

RIVET

Location

Loc Qty

Loc Code

ST558

22

M132703

22

MF 16-11-24

MS17984-C410

Purchased

No

140

Each

6.0000

1

1

MS17984-C410

QUICK PIN REPLACEMENT

Location

Loc Qty

Loc Code

over005

4

152625

4

ST315

2

150730

1

m128051

1

MF 16-11-24

MS21042L4

Purchased

No

140

Each

1,772.000

1

1

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

200

m135058

200

OVER007

500

m135979

500

ST303

1038

m135774

38

m135864

1000

MF 16-11-24

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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153621

Parent Item: PB67-43001-45

PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 11/23/2016

Required Date: 12/2/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

140

Each

4,033.000

2

2

NAS1149D0416J

WASHER

Location

Loc Qty

Loc Code

GA

55

m131511

55

ST260a

2492

m131511

2492

ST264

1486

m131511

1486

mf 16-11-24

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Shop Packet Print

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DQA: _____ Date: _____

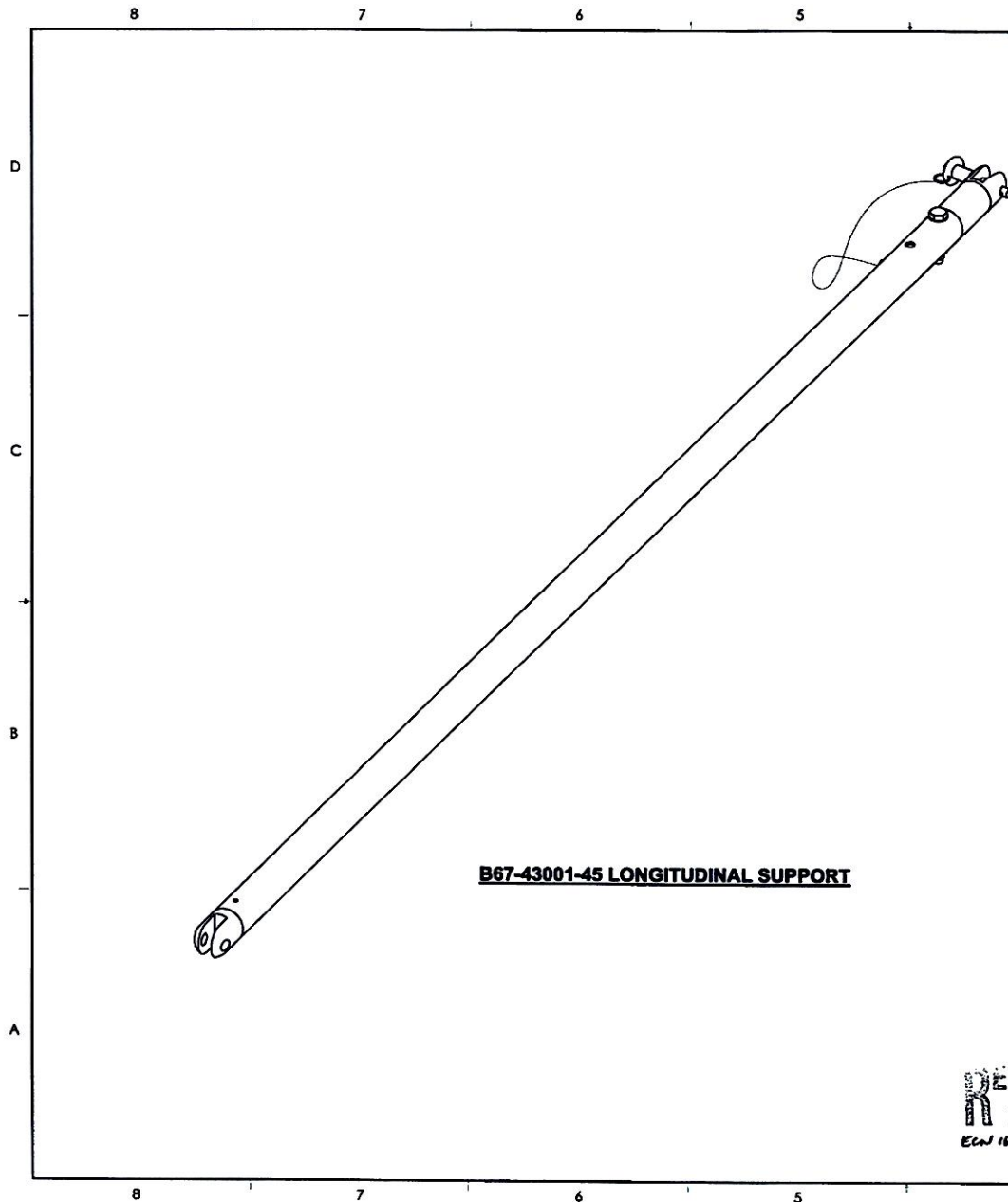
WORK ORDER NON-CONFORMANCE / UPDATE



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Misidentified ☐	Past Due ☐																																																																



B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	PIN, QUICK RELEASE
12	1	MS21042L4	NUT, SELF-LOCKING
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN632J	WASHER

△ D

D	CHANGE WASHER SIZE NAS1149DN632J WAS NAS1149DN416J (ZNC2-2) REASON, WEIGHT UPDATE, PAR15-437	SAD	16.10.17
C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR109-011)	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-45	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	LONGITUDINAL SUPPORT	NTS
DATE	16.10.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

RELEASED
2016-11-09
ECL 16-655

mf
#153621
16-11-22

